

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 157113

Monday, February 13, 2017 1:53:12 PM

157113

Page 2

Item ID: D5359-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clevis, Basket End

Start Date: 2/17/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/17/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.01

Quality Control

D.A. 17-02-17

4

φ

DAS
08
9-89

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.07

Packaging

LOCATION: WA001

4

DAS
6
9-89

FEB 21 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.01

Quality Control

17/2/22

FEB 21 2017

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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

1134 + 1614

Picklist Print

Monday, February 13, 2017 1:53:17 PM

Page 1

Work Order ID: 157113

157113

Parent Item: D5359-7

D5359-7

Parent Item Name: Clevis, Basket End

Start Date: 2/17/2017

Required Date: 2/17/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 17-01-20 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000		Purchased	No				f	17.5560		1.263158			

~~*M303B1 000*~~

303 Round Bar 1.00

M304 R1.000

DEF 17/02/15

**

Location

Loc Qty

Loc Code

MAT028

17.556

m136036

5.556

m136697

12

m136568

1.264

DAS
45
9-89

17-2-15

Material not pulled out

DQA: _____ Date: _____



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Work Order update only ☐

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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART AEROSPACE LTD		Work Order: 157113
Description: CLEVIS, BASKET END		Part Number: DS359-7
Inspection Dwg: DS359 Rev: B		Page 1 of 1

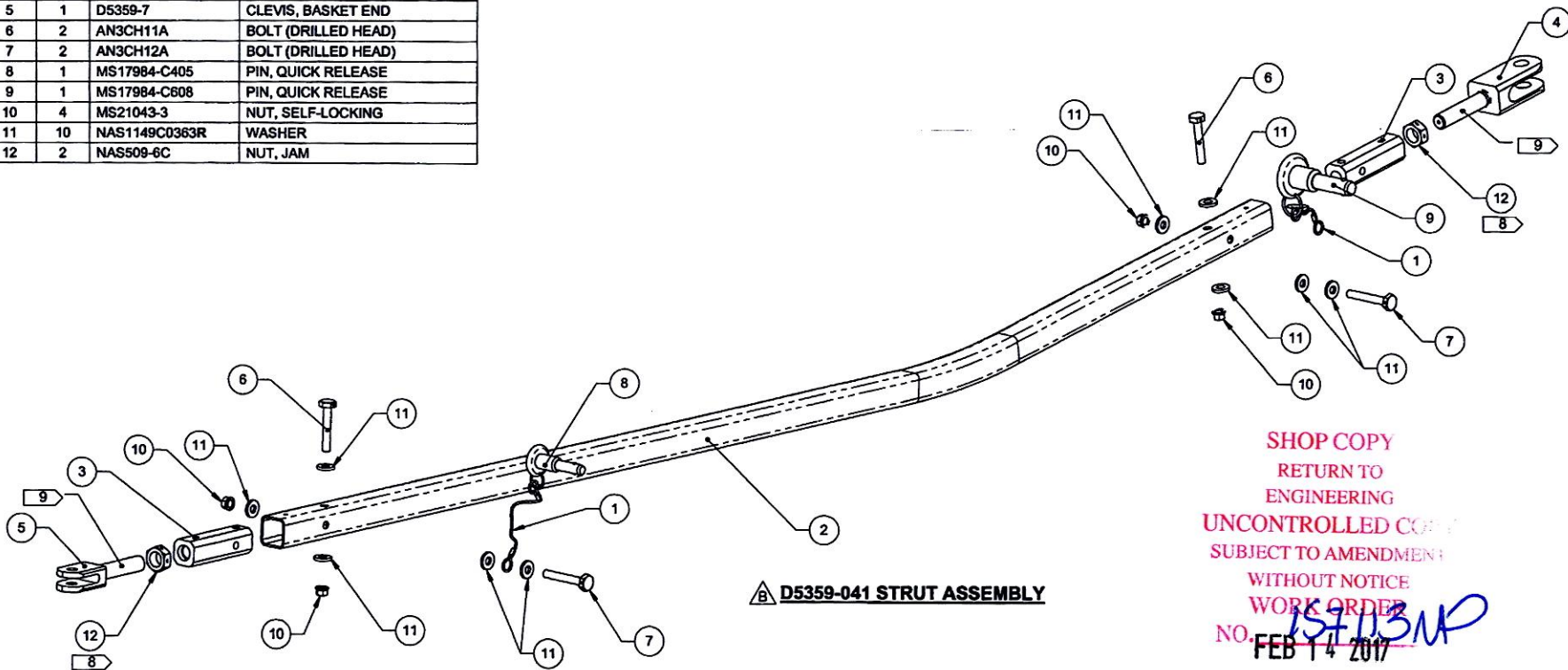
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.00	+/-0.03	2.998	✓		Caliper	JTC-01
1.000	+/-0.010	1.000	✓		↓	↓
1.750	+/-0.010	1.747	✓		↓	↓
0.110	+/-0.010	0.112	✓			
0.220	+0.010/-0.000	0.214	✓		cal + pin	JTC-01 Shop
0.500	+/-0.010	0.499	✓		mic 01	JTC-02
r.110	+/-0.010	r.112	✓		rad 6	Shop
0.031x450	+/-0.010	0.031x450	✓		depth gage	JTC-07
r.375	+/-0.010	r.375	✓		rad 6	Shop
0.375	+/-0.010	0.375	✓		Caliper	JTC-01
0.750	+/-0.010	0.748	✓		↓	↓
0.257	+0.006/-0.001	0.257	✓			
r.031	+/-0.010	r.031	✓		rad 6	Shop
1.650	+/-0.010	1.650	✓		Caliper	JTC-01
0.84	+/-0.03	0.840	✓		✓	✓
3/8-24 3A	NUT	OK	✓		Shop Nut	Shop
Ø MAX-MIN	0.375-0.3678	0.372	✓		mic 01	JTC-02
M.O.W. 0.029 MAX-MIN	0.3989-0.396	0.397	✓		✓	

Measured by: DAS 45 9-89	Audited by: DAS CB 9-89	Preliminary Approval:
Date: 17-2-15	Date: 17-02-17	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5359-041	STRUT ASSEMBLY
1	2	D2690-6	LANYARD ASSEMBLY
2	1	D5359-1	STRUT
3	2	D5359-3	INSERT
4	1	D5359-5	CLEVIS, AIRCRAFT END
5	1	D5359-7	CLEVIS, BASKET END
6	2	AN3CH11A	BOLT (DRILLED HEAD)
7	2	AN3CH12A	BOLT (DRILLED HEAD)
8	1	MS17984-C405	PIN, QUICK RELEASE
9	1	MS17984-C608	PIN, QUICK RELEASE
10	4	MS21043-3	NUT, SELF-LOCKING
11	10	NAS1149C0363R	WASHER
12	2	NAS509-6C	NUT, JAM



D5359-041 STRUT ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157113NP
FEB 14 2017

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 2.48 lbs
- 8) HAND TIGHTEN NAS509-6C NUT
- 9) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD

RELEASED
2017-02-10
EW13-508

APPROVED

B	REDESIGNED TO BE COMPATIBLE WITH BOTH LH + RH INSTALLATIONS. -042 DELETED.	AJS	16.12.12
A	NEW ISSUE	VS	15.11.23
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	NO		
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5359	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
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